

Date: Tuesday, 9/4/2008  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 34413	
Estimate Number : 12308	
P.O. Number :	Part Number : D34711
This Issue : 9/4/2007 S.O. No. :	Drawing Number : D3471 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 26612	Material :
Written By :	Due Date : 10/4/2007 Qty: 7 Um: Each
Checked & Approved By : <u>07.09.04</u>	
Comment : est rev A 06.03.02 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.1428 sf(s)/Unit Total : 6.8569 sf(s)

2024-T3 .063 sheet

Batch: M104921 Scrap=1

total 7

SAN 07/09/10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3471

Dwg Rev: A

Prog Rev: A

SAN 07/09/10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/09/10

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAN 07/09/10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr





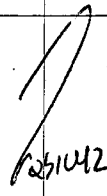
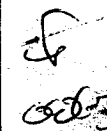
2-Bend as per dwg D3471

SAN 08/03/18

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3471-1 PAR #: NA Fault Category: POU/FAB-PSS' <sup>med & small</sup> NCR: Yes No DQA: D Date: 08/03/20  
 QA: N/C Closed: H Date: 08/03/24

NCR: <u>34413</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	2.0	wrong material size in Program. EC operator/Human error		Scrap, destroy, replace	SAB 07/09/10	Er 07/09/10		Er 07/09/10
		Dart change the thickness on water jet.						
08/03/18	S	1 part was scrap because out of tolerance Human error.		Scrap & destroy	SB 08/03/18			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34413

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*FL 08/03/19 (46)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FL 08/03/19 (6)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-H 08/03/19 (6X)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *160*

*9/3/19 50 (6X)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/03/20 (6)*

Job Completion



*mi 2008/3/19 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

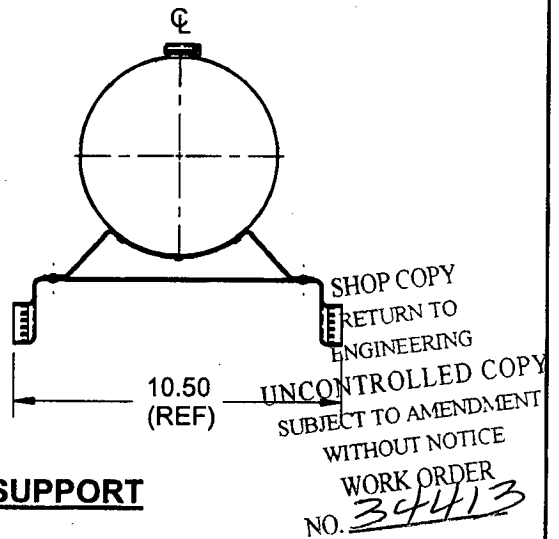
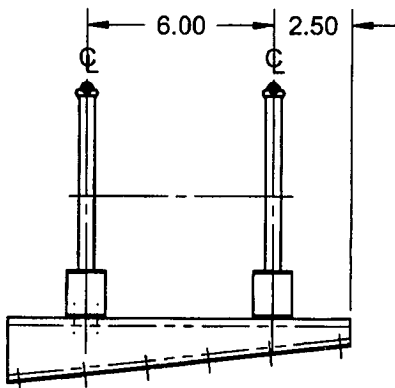
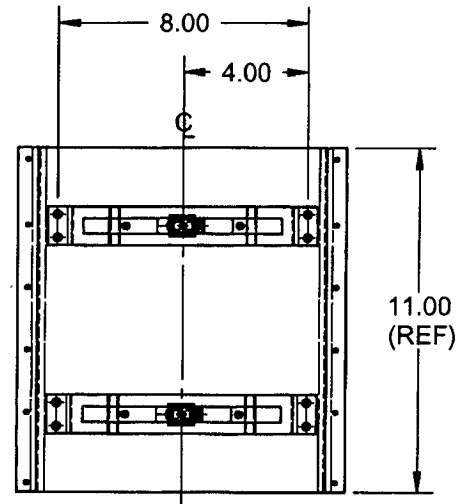
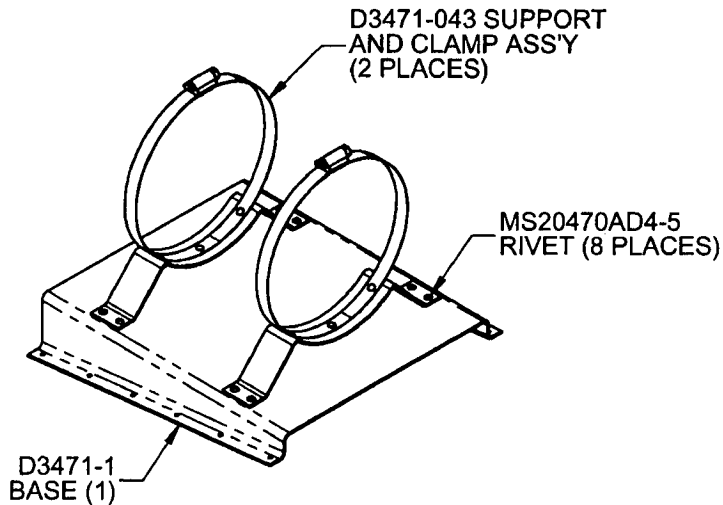
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:6
A	05.12.21	NEW ISSUE	

06-04-03 *[Signature]***D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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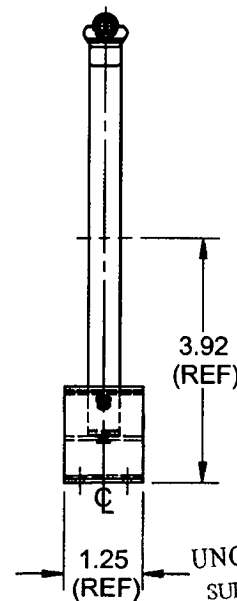
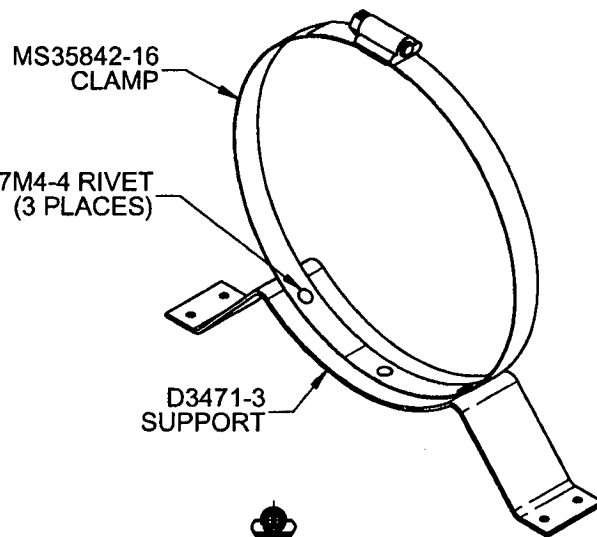
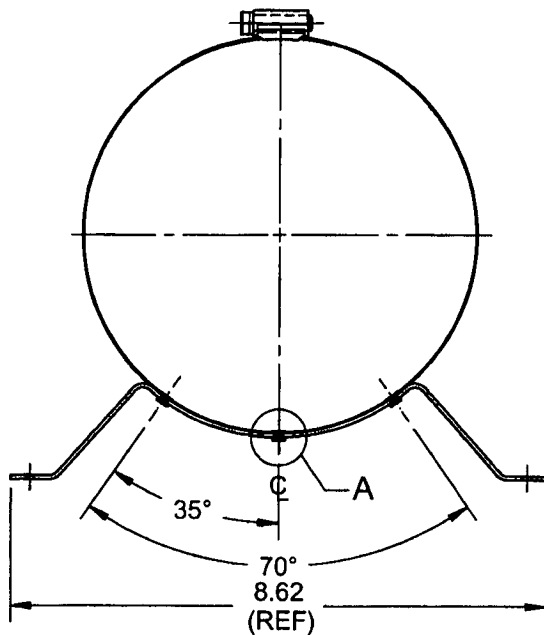
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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b> SCALE 1:3	

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL  
#30 ( $\phi 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\phi 0.230 \times 100^\circ$   
(3 PLACES)



**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1



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NO. *34413*

### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

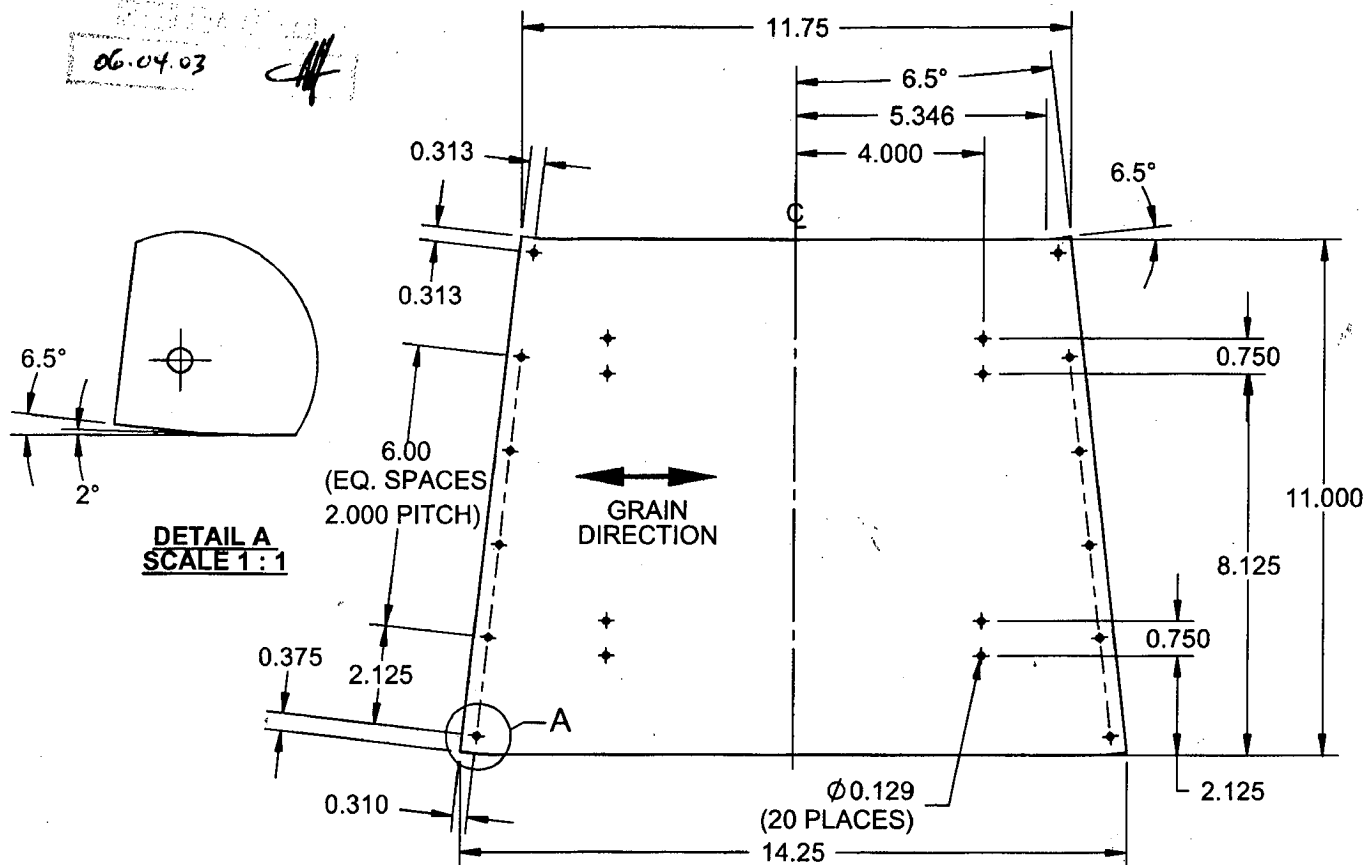
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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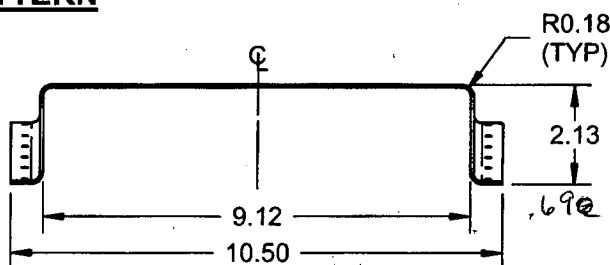
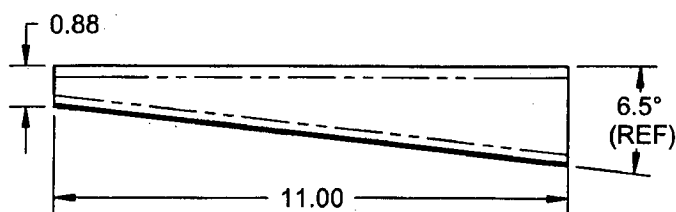
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DATE <b>05.12.21</b>	TITLE <b>BLOWER MOTOR SUPPORT</b>		SCALE 1:4



### D3471-1F BASE FLAT PATTERN



### D3471-1 BASE BENDING DETAIL

#### NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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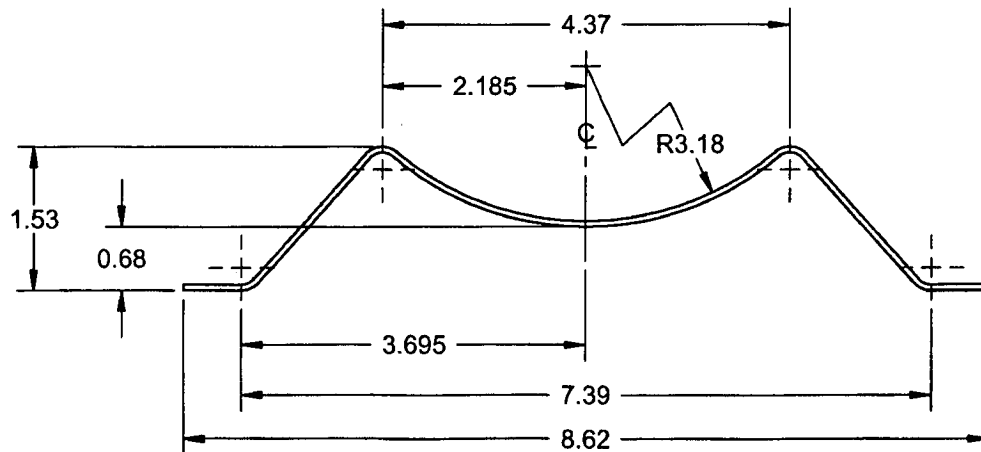
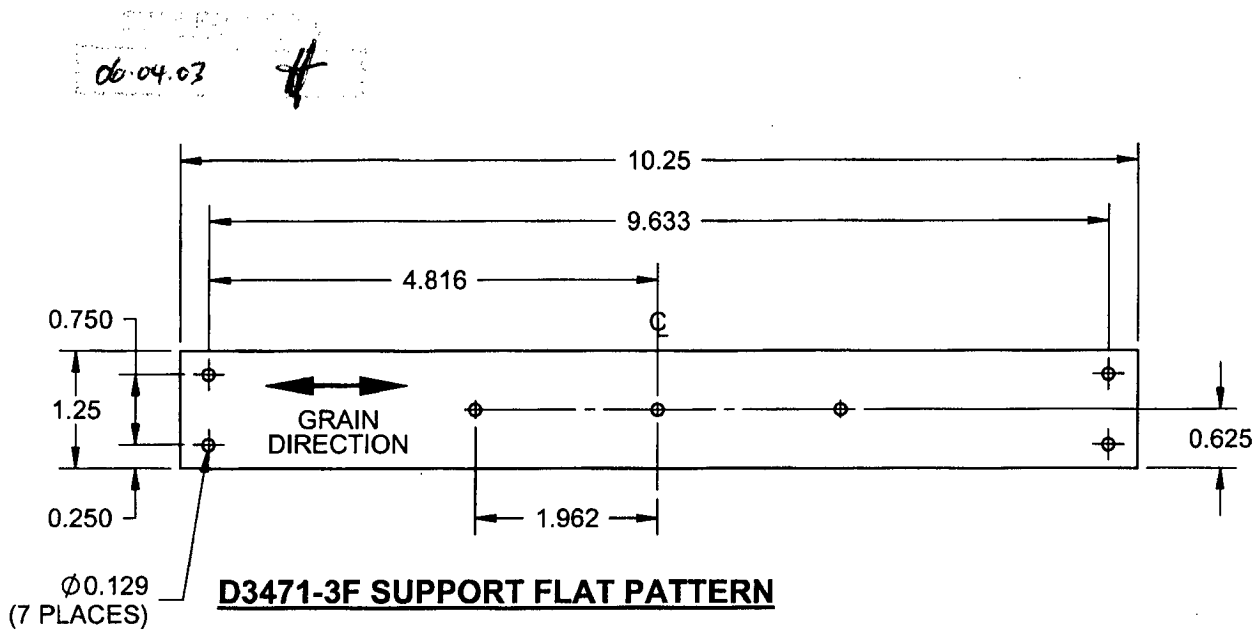
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DATE 05.12.21	TITLE BLOWER MOTOR SUPPORT		SCALE 1:2

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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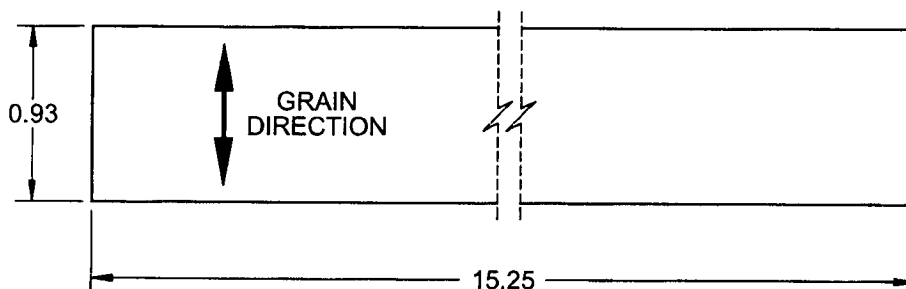
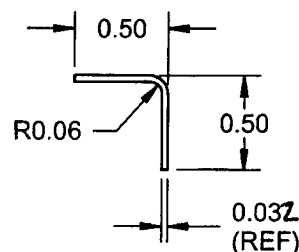
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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:1

06.04.03 *[Signature]***D3471-5F STIFFENER FLAT PATTERN****D3471-5 STIFFENER BENDING DETAIL****D3471-5 STIFFENER****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 34413
Description: BLOWER Motor Support		Part Number: D34711
Inspection Dwg: D34711 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.75	+/-0.030	11.76	✓		Vern	
0.313	+/-0.010	0.315	✓		Vern	
0.313	+/-0.010	0.316	✓		Vern	
2.000 (Pitch)	+/-0.010	2.002	✓		Vern	
6.00	+/-0.030	6.00	✓		Vern	
2.125	+/-0.010	2.127	✓		Vern	
0.375	+/-0.010	0.374	✓		Vern	
0.310	+/-0.010	0.309	✓		Vern	
14.25	+/-0.030	14.250	✓		<del>Vern</del> M-T	
2.125	+/-0.010	2.124	✓		Vern	
0.750	+/-0.010	0.755	✓		Vern	
8.125	+/-0.010	8.129	✓		Vern	
0.750	+/-0.010	0.755	✓		Vern	
11.000	+/-0.010	11.998	✓		Vern	
0.129	+0.005 -0.001	0.130	✓		Vern	

Measured by: SAN	Audited by: E	Prototype Approval: N/A
Date: 07/09/10	Date: 07/09/10	Date: 07/09/10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	